

Del 14 Work Order ID 72163

Tuesday, July 19, 2011 1:50:47 PM



Page 1

Item ID: D3455-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 7/19/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

[Handwritten signature]

Date:

7-19-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3455

Rev A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA584 & DWG D3455, □FOLIO
REV: *A* □DWG REV: *A* □2-DEBURR AS REQUIRED

SA 418110

23 *φ*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 418110

23 *φ*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

B.A 11/08/10

23 *φ*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 Small Fab | Small Fab | 0.00 | | | | 23 | | | |
| Small Fab | Memo Deburr if necessary. | 0.00 | | | | | | | |
| 140 QC | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| Quality Control | Memo | 0.00 | | | | | | | |
| 150 Packaging | Identify as per dwg & Stock Location: | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |

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NOTE: Date & initial all entries

Work Order ID 72163

Tuesday, July 19, 2011 1:50:47 PM



Page 3

Item ID: D3455-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 7/19/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/10

11-08-10 (23)

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 1:50:53 PM

Page 1

Work Order ID: 72163

Parent Item: D3455-3

Parent Item Name: Spacer




Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MDELRLNR1.000  | | Purchased | No | | | 100 | f | 28.2680 | 0.022 | 0.463158 | | | |
| Delrin Round Bar 1" | | | | | | | | | | | | | |

31 11/8/10

Location

MAT055

117985

118257

Loc Qty

28.268

0.407

27.861

Loc Code

St

| W/O: | | WORK ORDER CHANGES | | | | | |
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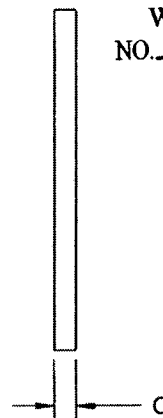
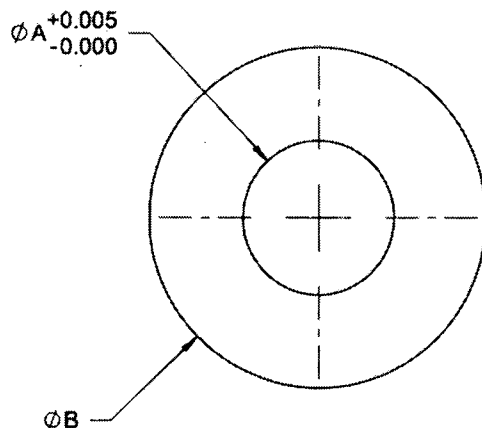
| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3455 | REV. A SHEET 1 OF 1 |
| DATE 05.09.02 | | TITLE SPACER | SCALE 2:1 |
| A | 05.09.02 | NEW ISSUE | |

RELEASED

05.12.09 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72163

11-07-19



D3455-X

1) SPECIFICATION: D3455-X SPACER

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

| DASH No. | A (in) | B (in) | C (in) |
|----------|--------|--------|--------|
| -1 | 0.453 | 1.00 | 0.065 |
| -3 | 0.386 | 1.00 | 0.050 |

NOTES:

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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